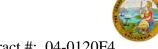
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

### WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-003711 Address: 333 Burma Road **Date Inspected:** 26-Aug-2008

City: Oakland, CA 94607

**OSM Arrival Time:** 1400 **Project Name:** SAS Superstructure **OSM Departure Time:** 2300 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes Huang Wen Pang No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:** 

**Bridge No:** 34-0006 **Component:** OBG

### **Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe fabrication and perform Ultrasonic Testing (UT) of Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Tower Heavy Machinery Shop Bay # 2

The Caltrans QA Inspector measured and marked Y locations of indications of Deck Panel DP004-001 U-rib GMAW tack welds found with conventional Ultrasonic testing. Indications were evaluated with phased array ultrasonic testing and recorded by Caltrans QA.

Sub Assembly Shop Bay # 3

The Caltrans QA performed Ultrasonic Testing (UT) Verification of OBG WT stiffener web and flange Complete Joint Penetration (CJP) weld joints, FB079-001-032, SP313-001 welds 048, 049, 050 and 052, SP100-001 welds 048, 049, 050 and 052, SP127-001 welds 041, 042, 043 and 045, SP154-001 welds 041, 042, 043 and 045, SP367-001 welds 041, 042, 043 and 045, SP340-001 welds 041, 042, 043 and 045. Ultrasonic testing was performed from face "A" with a 70 degree transducer and evaluated in the first and second leg on flange welds. 10 mm web plates were also evaluated in the 3rd leg due to the material thickness.. The welds tested appeared to be in general conformance with AWS D1.5 table 6.3 and contract documents. See UT report TL-6027 generated on this date for further information.

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

## **Summary of Conversations:**

Only general conversations between Caltrans QA and QC occurred this date.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138 1694 2685, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer